

Work Order ID 86877-2

July-09-12 9:13:07 AM

D2855

Split

86877

Page 1

Item ID: D2855-3

Revision ID:

Item Name: Cap

Start Date: 7/09/12

Start Qty: 10.00

10

Required Date: 7/20/12

Req'd Qty: 10.00

10

Reference:

Approvals:

Process Plan:

Date: 12-07-10

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2855

Rev B

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 17/104

Cast per Dwg D2855

Material Release Note Required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

120

QC'6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

40

12-07-10

40

50X

12-7-18

100%
40

Work Order ID 86877

86877

Page 2

July-09-12 9:13:07 AM

Item ID: D2855-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cap

Start Date: 7/09/12

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/20/12

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Small Fab

Memo

1- Drill as per Dwg D2855 using DT8235
2- Open holes to 19/64"
3- Cut to length as per dwg
4- Deburr

0.00

0.00

50

φ

At
12.07.30
12.08.16

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

see w/o 89802

150

150

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

0.00

0.00

↓

Work Order ID 86877

July-09-12 9:13:07 AM

86877

Page 3

Item ID: D2855-3

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cap

Start Date: 7/09/12

Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/20/12

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

Small Fab

0.00

170

Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D2855

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

*see also 89802**W*

Work Order ID 86877

86877

Page 4

July-09-12 9:13:07 AM

Item ID: D2855-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cap

Start Date: 7/09/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 7/20/12 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: GA

0.00

190

Packaging

Memo

0.00

Packaging

See
w/o
89802

40

SB

2/09/07

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

To Be Completed on w/o 89802

HJ

U 12.09.12

Picklist Print

July-09-12 9:13:07 AM

Page 1

Work Order ID: 86877

Parent Item: D2855-3

Parent Item Name: Cap

Start Date: 7/09/12

Required Date: 7/20/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225 INSERT		Purchased	No			170	Each	3,370.0000	2	20			

Location	Loc Qty	Loc Code
FP-B	2452	
122290	2452	
ST282	918	
100896	135	
111529	27	
118520	756	

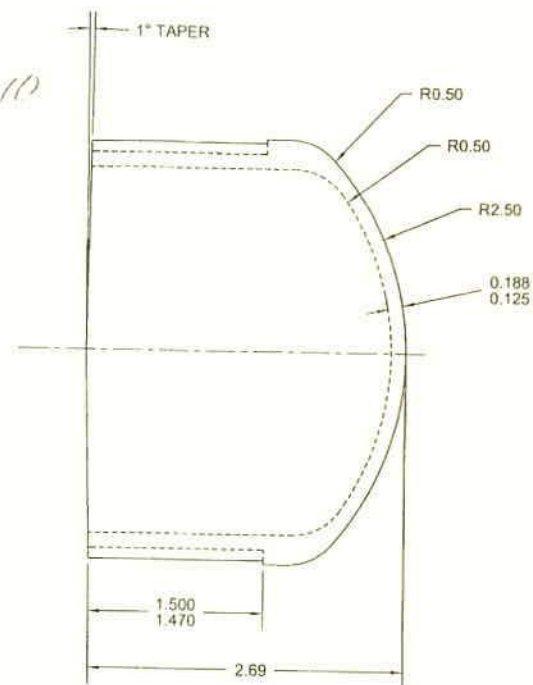
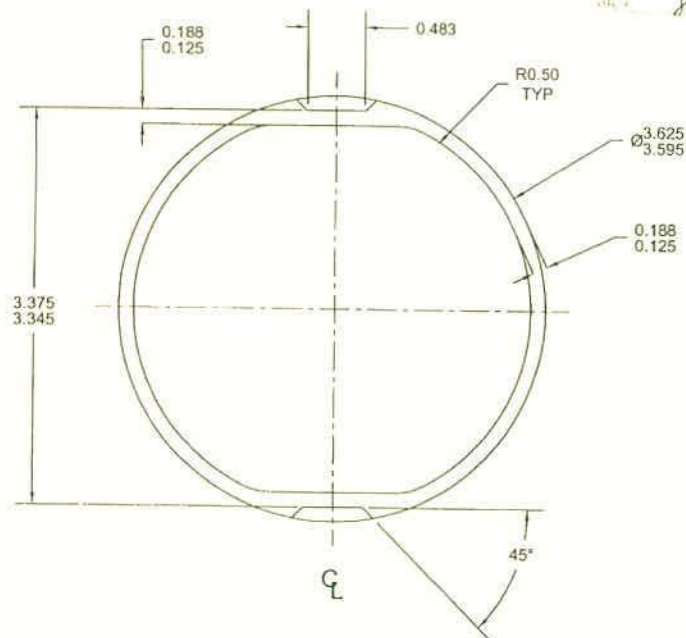
D2855P

Cap

Purchased No 110 Each 100.0000

Location	Loc Qty	Loc Code
ST	100	
84952	100	

10 40 B8877 SP.



D2855C CASTING DETAIL



NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

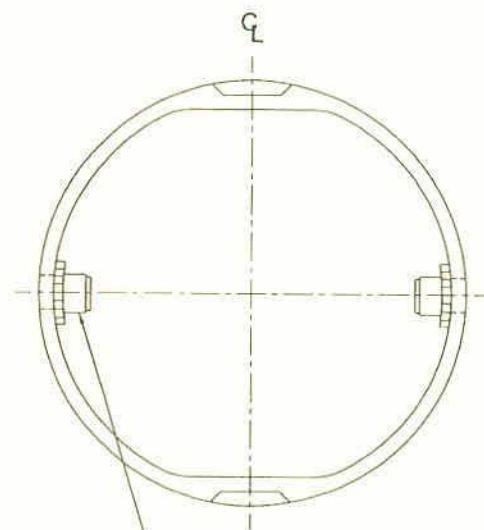
RELEASED
09/07/13

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	RF		
CHECKED	<i>RF</i>		
MFG. APPR.	<i>RF</i>		
APPROVED	<i>RF</i>		
DE APPR	<i>RF</i>		
DATE	09.06.30		

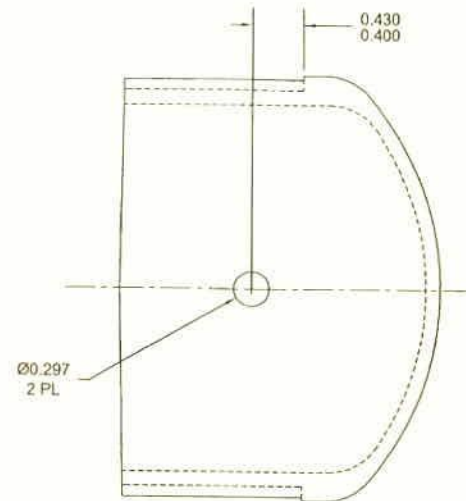
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D2855 SHEET 1 OF 3
TITLE SCALE
CAP NTS

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8/6/77



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

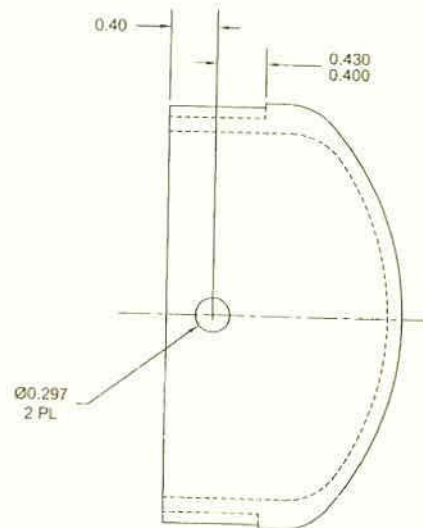
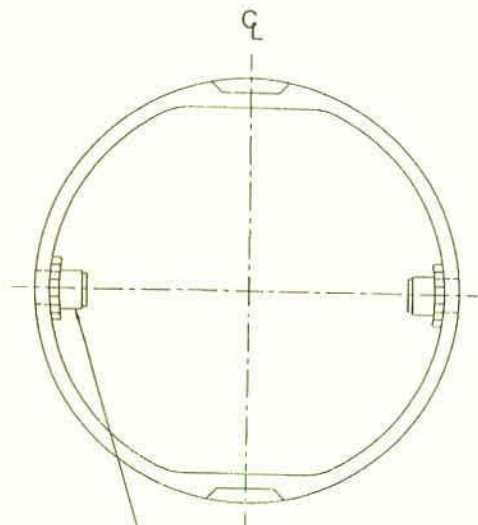
D2855 CAP (MAKE FROM D2855C CASTING)

RELEASED
31/07/19 MJP

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: PODER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP
(MAKE FROM D2855C CASTING)

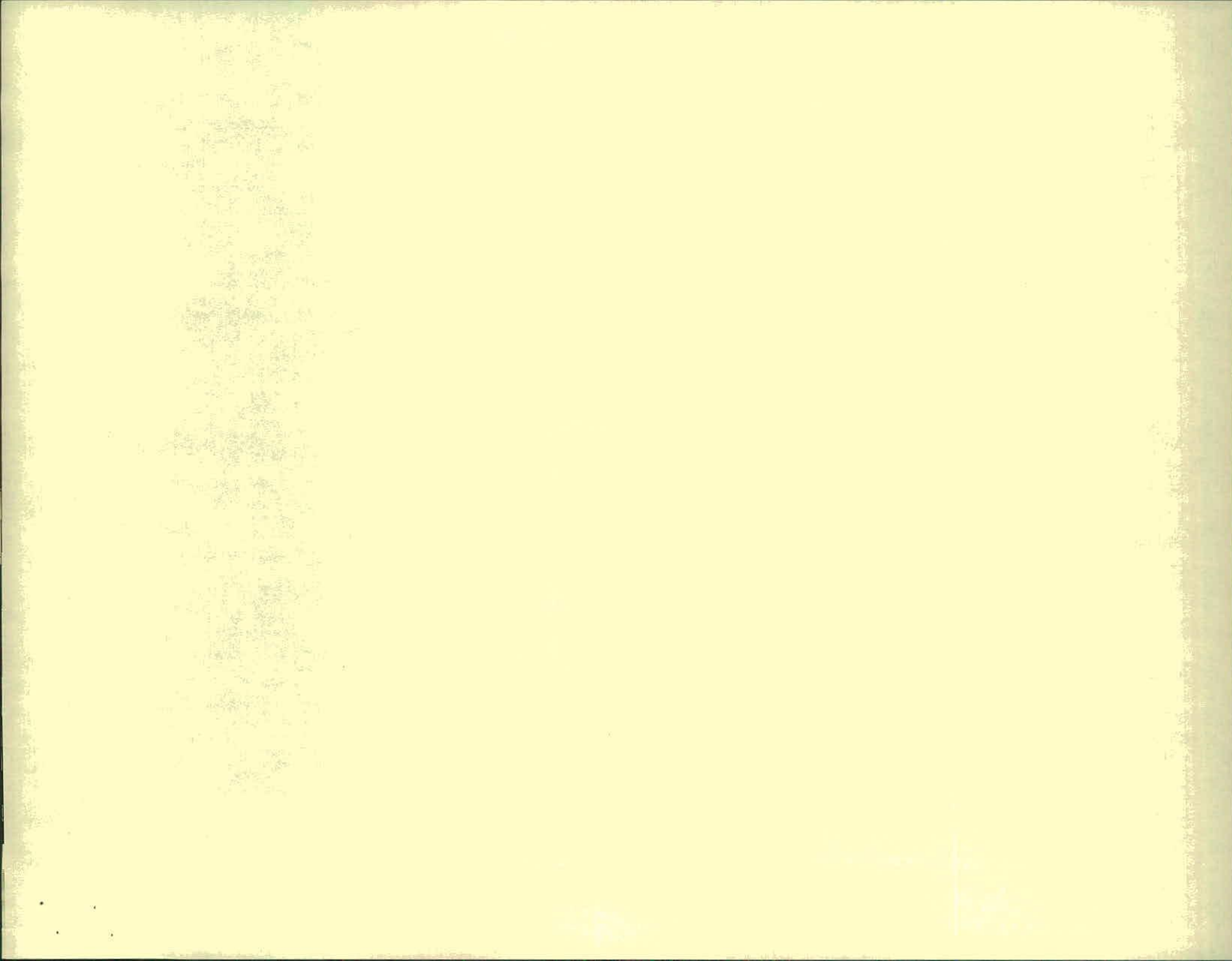
86-877

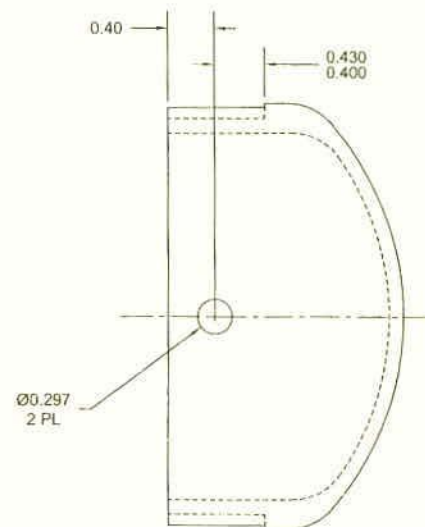
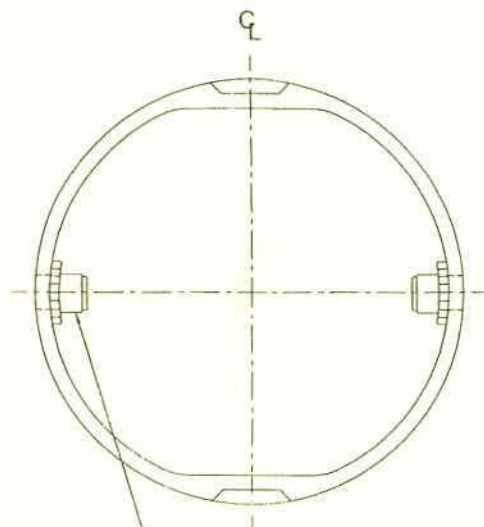
RELEASED
2016/15/13

NOTES:


- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D2855	SHEET 3 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CAP	NTS
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INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

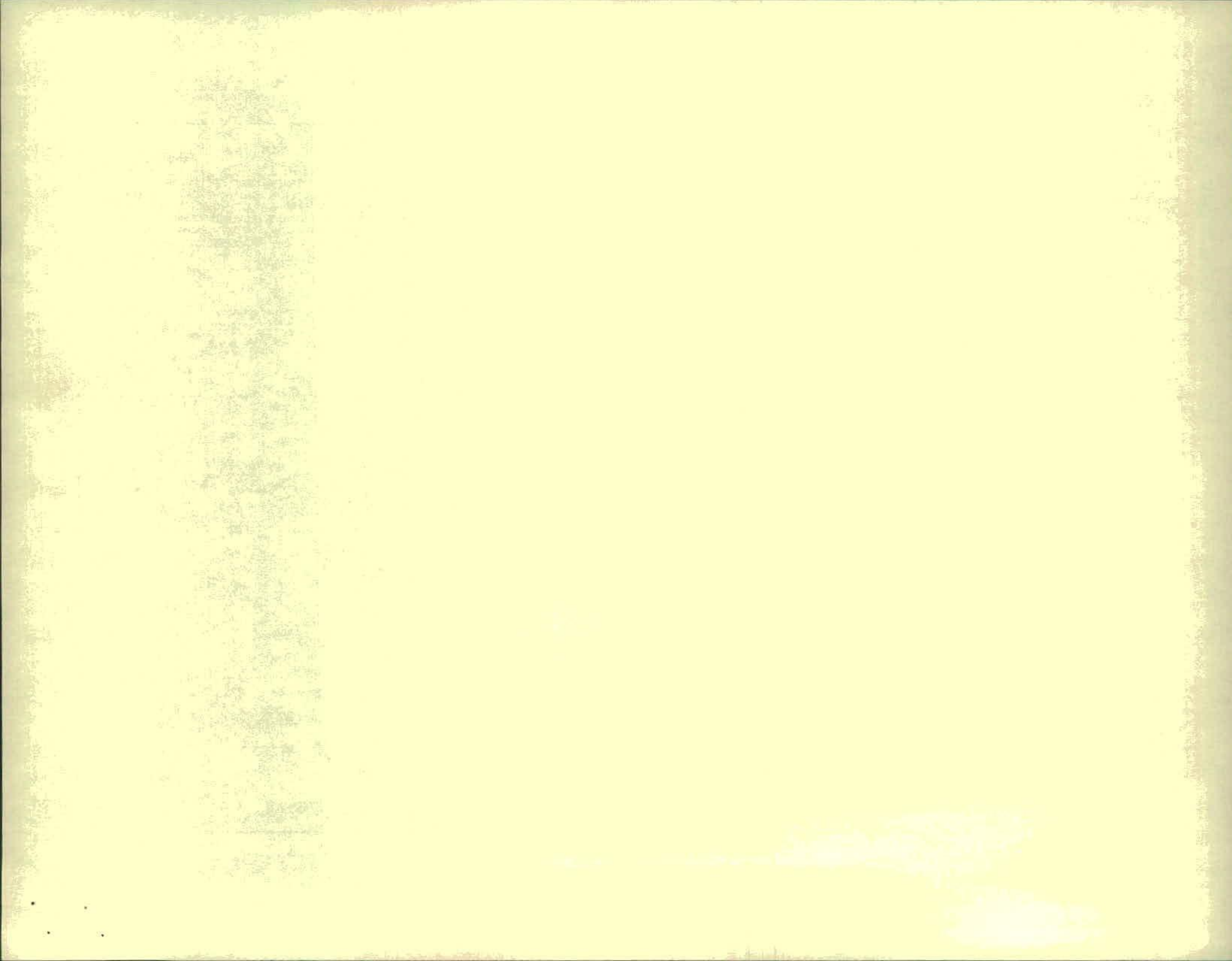
D2855-3 CAP 
(MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2855	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CAP	NTS
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RELEASED
09/07/2010





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17404

Purchase Order Date 7/10/2012

PO Print Date 7/10/2012

Page Number 1 of 1

Order From :

VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.
2225 CHEMIN ST. FRANCOIS
DORVAL, QC H9P 1K3
CA

Contact Name

Vendor Phone 514 683 9777

Vendor Fax 514 683 0375

Vendor Account Nbr

Buyer

Brigitte Golden

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
CZ 2/10/7/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
102855P		Cap	7/27/2012 Yes	50.00 Each	FedEx PI collect	\$18,7000	\$935.00

Special Inst: As per DWG: D2855 Rev:B
B86877
MAT: A356.2(F)

PO Total:

\$935.00

MATERIAL CERTIFICATION
REQUIRED UPON DELIVERY

Change Nbr: 2

Change Date: 7/10/2012

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required **YES** NO

Brigitte Golden

From: Brigitte Golden <bgolden@dartaero.com>
Sent: Tuesday, July 10, 2012 2:23 PM
To: 'Aluminum Foundry'
Cc: clavoie@dartaero.com; L Lacelle (llacelle@dartaero.com)
Subject: RE: New PO17404 from Dart
Attachments: PO17404 Aluminum Foundry.pdf

Thank you

Please find attached the revised PO

Also i have changed the date, but keep trying for July 16th...

Regards

Brigitte Golden

From: Aluminum Foundry [<mailto:info@foundryafpw.com>]
Sent: Tuesday, July 10, 2012 2:19 PM
To: 'Brigitte Golden'
Subject: RE: New PO17404 from Dart

Good afternoon!

There is a minimum 50 pcs order to avoid the surcharge of \$150.00. Please let us know how you want to proceed.

Our standard delivery time is 3 to 4 weeks. We will try our best but we cannot guarantee delivery 16th of July.

Thank you,

Roxana Dima
Aluminum Foundry & Pattern Works Ltd.
2225 Chemin St. Francois, Dorval, QC, H9P 1K3
Tel. (514) 683 9777
Fax (514) 683 0375

From: Brigitte Golden [<mailto:bgolden@dartaero.com>]
Sent: Tuesday, July 10, 2012 1:24 PM
To: 'info'
Cc: clavoie@dartaero.com; L Lacelle
Subject: RE: New PO17404 from Dart
Importance: High

Good Afternoon!

Please confirm on this new PO attached.

Regards

Brigitte Golden

Document Control

DART AEROSPACE Ltd.

70 CERTIFICAT DE CONFORMITE
CERTIFICATE OF COMPLIANCE

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

2225 CHEMIN ST. FRANCOIS, DORVAL, QC H9P 1K3
TEL. (514) 683-8777 FAX. (514) 683-0375

Expéditeur / Shipped	DART AEROSPACE	A.R. & P.M. Série no / Serial no	
	1270 Aberdeen Street	Date	18/07/2012
	Hawksbury, ON, K6A 1K7	Packing Shp No	34093, 34094
		Votre No. / Commande	17343, 17404
		Your order No.	

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents ou evidence des rapports et certificats de détaillants sont en file dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documents or evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Spécifications Specifications	Note d'autorisation Incoming Release note
60	D 2855 CAP	Z098046	A355.2	B# 1219401
50	D 2855 CAP	Z098046	A356.2	B# 1219401

DA
17/07/12

Analyse
Analysis (see in Ingots C - 626 1819)

(Si)	7.1%	(Al)	balance
(Fe)	0.10%		
(Cu)	<0.01%		
(Mn)	<0.01%		
(Mg)	0.32%		
(Zn)	<0.01%		
(Ti)	0.12%		

Donnée Yield	Résistance à la tension Tensile Strength :	Allongement par pouce carré P.S.I. Elongation :
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Pour et au nom de
For and on behalf of:

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

Dept/Dep :
Part/Per : 

Doc-100

